

Date: Tuesday, 28/10/2008 2:02:05 PM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: X-BOLT SPACER
Job Number	: 43013		
Estimate Number	: 12321		
P.O. Number	:	Part Number	: D34901
This Issue	: 28/10/2008 S.O. No. :	Drawing Number	: D3490 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 42780	Material	:
Written By	: <u>JLM 08.10.28</u>	Due Date	: 04/11/2008 Qty: 100 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 06-03-03 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T0500W049	6061-T6 RD Tube .500 x.049W
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Comment: Qty.: 0.2793 f(s)/Unit Total : 27.9300 f(s)

6061-T6 Tube .500 x.049W

(M6061T6T0.500W.049)

Batch: M108250, M107315 → 13ft, M10960 → 8ft

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1-TURN AS PER FOLIO FA628 & DWG D3490

FOLIO REV: ADWG REV: A

2-DEBURR AS REQUIRED

08/10/28

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE 08/10/28

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Partney

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-BOLT SPACER

Job Number: 43013

Part Number: D34901

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



100

Comment: FINAL INSPECTION/W/O RELEASE

SD 08/10/29

Job Completion




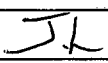
U 08/10/29



DART AEROSPACE LTD		Work Order:	43013
Description: Crossbolt Spacer		Part Number:	D3490-1
Inspection Dwg: D3490 Rev: A		Page 1 of 1	

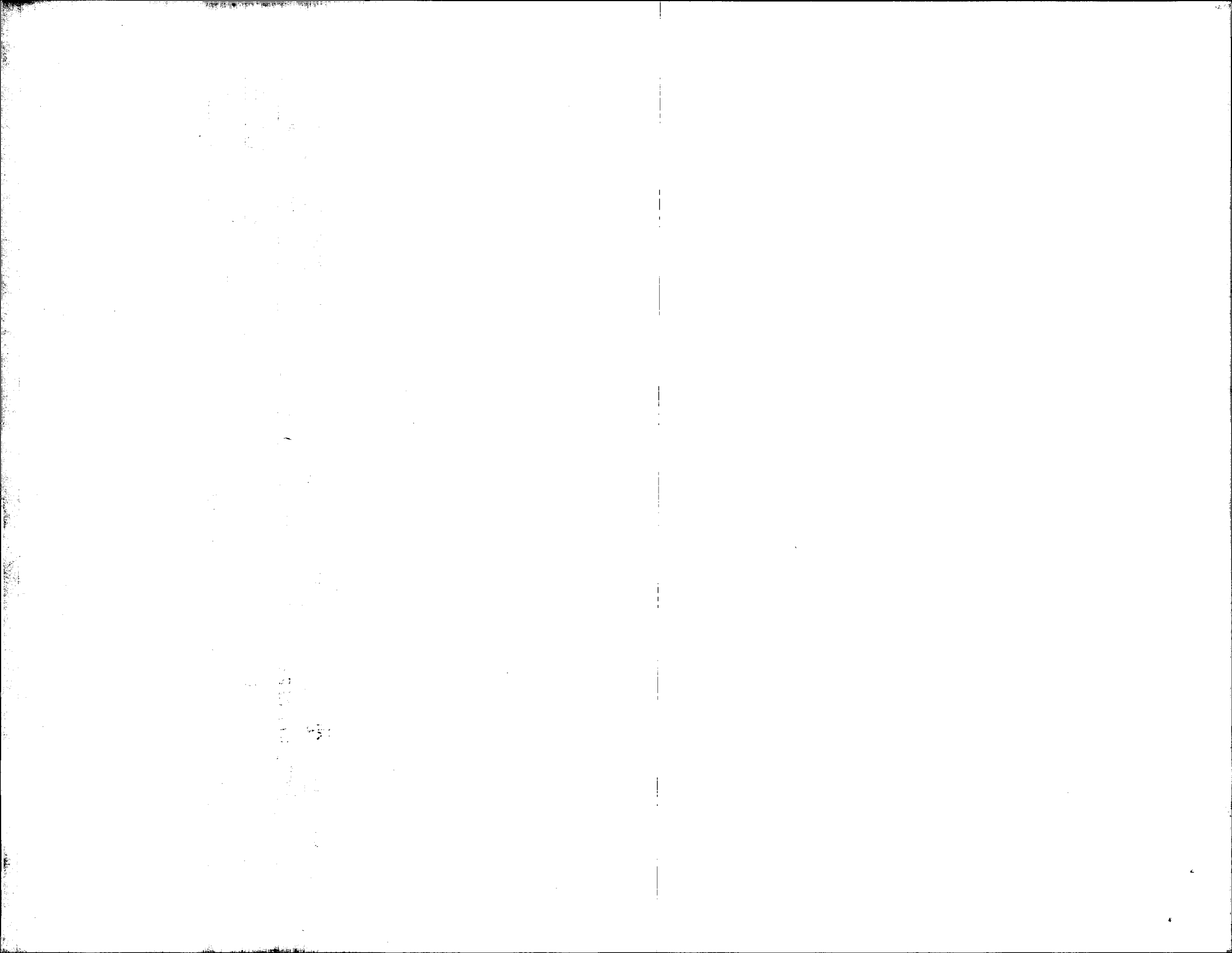
FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.500	+0.006/-0.001	.4995				
0.049	+/-0.010	.047				
Ø0.402	+0.006/-0.001	3.102 .402				
3.085	+0.030/-0.000	3.102				
0.050 x 45°	+/-0.010	0.051 x 45°				

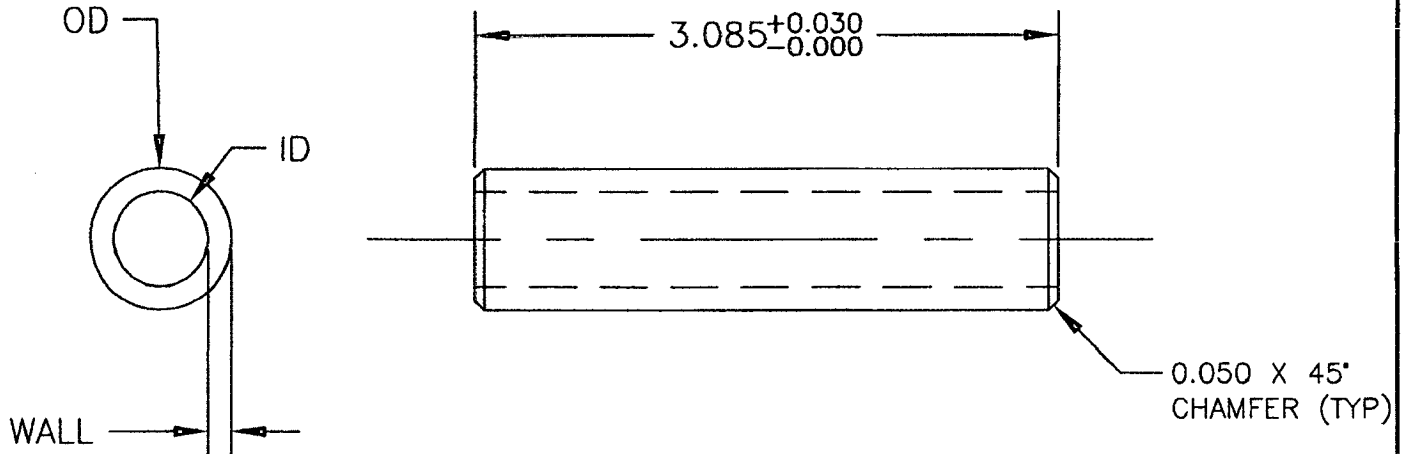
Measured by: 	Audited by: 	Prototype Approval:	N/A
Date: 08/10/28	Date: 08/10/28	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.06	New Issue	KJ/JLM	
B	08.06.02	Dimensions and tolerances revised	KJ/DD	
C	08.10.07	0.050 x 45° dimension revised	KJ/DD 	





DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3490	REV. A SHEET 1 OF 1
DATE 06.01.04		TITLE CROSS BOLT SPACER	SCALE NTS
A	06.01.04	NEW ISSUE	



D3490-1/-3/-5 CROSS BOLT SPACER PARTS LIST

PART NUMBER	OD	WALL	ID (REF)	MATERIAL SPEC
D3490-1	0.500	0.049	0.402	M6061T6T0.500W.049
D3490-3	0.750	0.080	0.591	M6061T6R0.750
D3490-5	0.313	0.058	0.197	M6061T6T0.313W.058

D3490-1/-3/-5 CROSS BOLT SPACER

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

w/o 43013

RELEASED
do-02-07

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